



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G04132-3G-6

Job Sheet 198052



Part No: RBW6405G04132-3G-6

Job Qty: 4 pcs

Part Name: Rod



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/22/19

Job Tracking No:

Due Date: 9/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G04132-3G Rev.E IPP Rev. A 19.03.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign off
					Setup Hrs	Run Hrs		
100	SL-2500Y - 1	4 pcs	9/20/19	9/20/19	1.00	0.80	SL-2500Y - 1	 19/09/19
120	QC 8	4 pcs	9/20/19	9/20/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
130	Outsource - 12 - Black Oxide	4 pcs	9/20/19	9/20/19			GRO002-VC	 20/09-09-17
140	Packaging 2-1 - Receive - B4B	4 pcs	9/20/19	9/20/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	



Container No: S213589



Part: RBW6405G04132-3G-6

Job No: 198052

Serial No/Batch: S213589

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 09/13/19

DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DAS
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9-89

				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP
				Packaging 2 - 14 - B4B	SEP 2 5 2019
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 6	4 pcs	9/20/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	SEP 2 6 2019
				QC 6 - 81	DAS 40 9-80
160 Packaging 3-1 - Stock - B4B	4 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170 QC 21 - SA	4 pcs	9/20/19	0.00 0.00	QC 21 - SA - 21	SEP 2 7 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Machine as per folio FC713 FOLIO REV: _____ DWG REV: _____ 2-Deburr
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - -Issue P/O; 44523 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-

7/22/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;
Stress Proof -Certificate of Conformity is required
140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required
150 - QC6- All purchased or subcontracted products
160 - Identify as per dwg & Stock Location: _____
170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.000	AISI 4140 Quenched & Tempered Steel Round Bar 2.000" Dia.	5.8400 ft (1.46 ea)	100-SL-2500Y - 1	M138470 5116718

Job Allocations

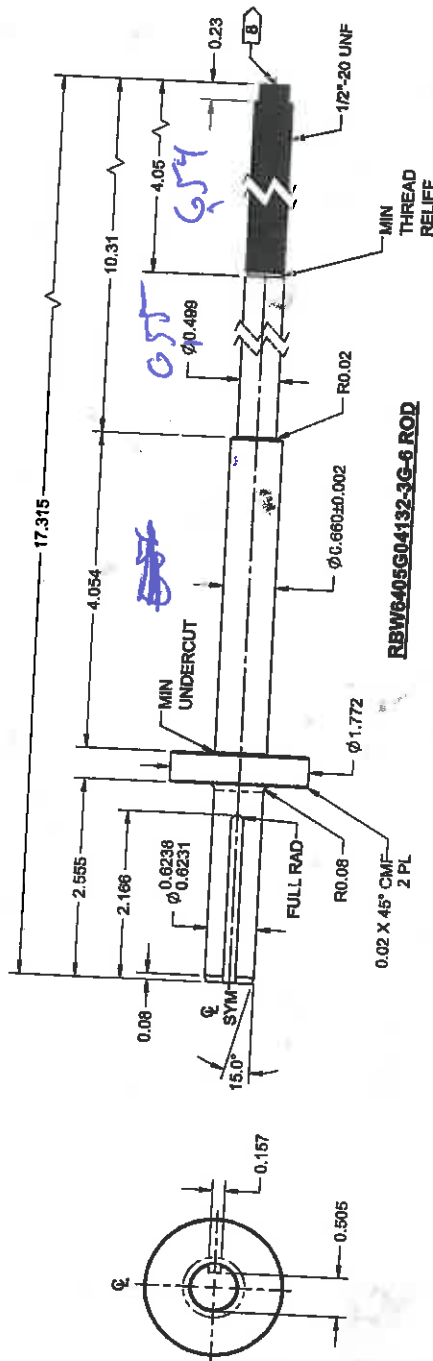
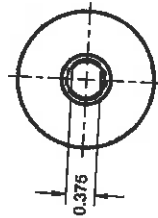
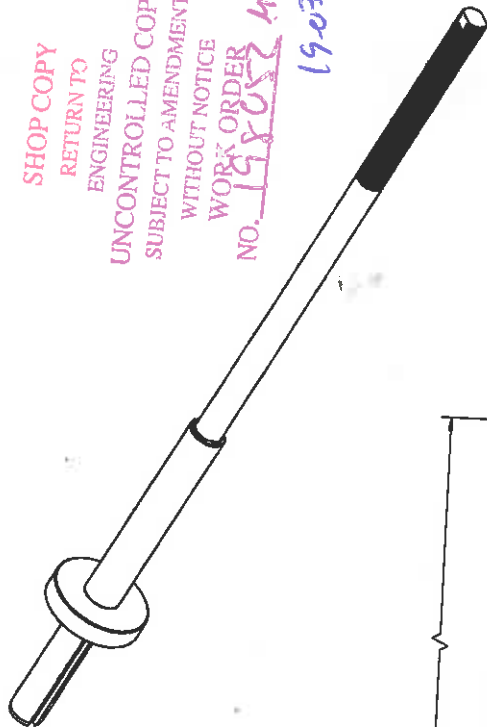
Operation	Component Part	Required	Inventory	Allocated
100-SL-2500Y - 1	MT-4140QT-R2.000	6	10	0

Part Specifications

Specifications could not be found.

Plex 7/22/19 8:11 AM Dart.lajeunesse.marie

NO. 158057405



RBW6405G04132-3G-6 ROD

NOTES:
1) MATERIAL: 4140 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13024 CLASS 1 THEN APPLY A THIN LAYER OF OIL / 7°C PER MIL-PRF-16713 GRADE 3
OR MIL-C-2341A OR MIL-PRF-91309 AND WASTE 1 OR MIL-C-81309 TYPE II
4) TOLERANCES: X.X = ± 0.1 "

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A
8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM
DRAWN	VM
CHECKED	VM
MFG. APPR.	RQ
APPROVED	VM

DATE 3/1/2019

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #

RBW6405G04132-3G

T/R DUPLEX BEARING INSTALLATION SCALE

REV. E

0-70113

Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____

DEPARTMENT/PROCESS

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

MRB (QSI042)

Sequence #: _____

QTY Affected: _____

Disposition

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____

DART AEROSPACE LTD		Work Order: 198052
Description: Rod	Part Number: RDW640564132-26-6	
Inspection Dwg:	Rev: E	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
17.315	$\pm .005$	17.316			Caliper	
4.05	$\pm .01$	4.048			Caliper	
10.31	$\pm .01$	10.308			Caliper	DAS
4.054	$\pm .005$	4.053			Caliper	5
2.555	$\pm .005$	2.556	✓		Caliper	9-89
2.166	$\pm .005$	2.163			Caliper	
.23	$\pm .01$	.232			Caliper	
.375	$\pm .005$	.376			Micrometer	
.157	$\pm .005$	.156			Caliper	
.505	$\pm .005$	.506			Caliper	
1/2-20 NF	N/A	N/A			Go/NoGo	
Ø .495	.4906-.4987	.495			Micrometer	
Wire .032	.5146-.5189	.517			Micrometer	
Ø .499	$\pm .005$	.4975				
Ø .660	$\pm .002$	.6605				
Ø 1.712	$\pm .005$	1.711				
Ø .6231	.6231-.6238	.6236			Micrometer	DAS
						5
						9-89
Ø .000	$\pm .005$	.003				

Measured by: [Signature]	Checked by: [Signature]	QC Inspector:
Date: 19/09/12	Date: 19/09/14	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044523**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044523

PO Date: 9/17/19

Due Date: 9/25/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-20

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198284	RBT18635-3	Spud -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/25/19	4 pcs	0 pcs	4 pcs	\$5.96/pcs	\$23.84
2	198282	RBT18635-1	Adapter Bushing -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	9/25/19	4 pcs	0 pcs	4 pcs	\$0.99/pcs	\$3.96



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PURCHASE ORDER

POHB044523



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	200410	RBW5605G00551-3G-1	Shoe -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.11/pcs	\$1.11
4	198052	RBW6405G04132-3G-6	Rod -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Stress Proof -Certificate of Conformity is required	Firmed	-	9/25/19	5 pcs	0 pcs	5 pcs	\$9.90/pcs	\$49.50
5	196252	RBSC7028-P-5	Cutter Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/25/19	10 pcs	0 pcs	10 pcs	\$2.87/pcs	\$28.70



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199561	RBW6522A00231-W142AK-3T	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	9/25/19	6 pcs	0 pcs	6 pcs	\$8.43/pcs	\$50.58
7	196076	RBW5605G00251-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.51/pcs	\$1.51
8	196078	RBW5605G00351-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.48/pcs	\$1.48



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PURCHASE ORDER

POHB044523



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	196079	RBW5605G00551-3G-3	Handle -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Tool steel -Certificate of Conformity is required	Firmed	-	9/25/19	1 pcs	0 pcs	1 pcs	\$1.41/pcs	\$1.41
										Grand Total:	\$162.09

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/20/19 11:02 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022506-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022506 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
24-Sep-2019		Jigar Patel		POHB044523					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBT18635-3 Rev.	RBT18635-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	4	4	0	0	0	
2	RBT18635-1 Rev.	RBT18635-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	BLACK-OXIDE CH	4	4	0	0	0	
4	RBW6405G04132-3G-6 Rev.	RBW6405G04132-3G-6 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5	0	0	0	
7	RBW5605G00251-3G-3 Rev.	RBW5605G00251-3G-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0	
8	RBW5605G00351-3G-3 Rev.	RBW5605G00351-3G-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0	
9	RBW5605G00551-3G-3 Rev.	RBW5605G00551-3G-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	1	1	0	0	0	

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RECEIVED

SEP 24 2019

DART AEROSPACE LTD.



Certificat de Conformité / Certificate of Compliance

(022506-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
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 www.groupaltech.com

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022506 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
24-Sep-2019		Jigar Patel		POHB044523				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

J. Jay

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.